

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016927**Date Inspected:** 24-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance Inspector (QAI) Bert Madison was present at Yerba Buena Island in California between the times noted above for observations relative to the work being performed by American Bridge/Fluor Enterprises (AB/F) personnel at the locations noted below.

- 1). OBG Field Splice 6E/7E weld ID: A1, Face A (R-1 UT Repairs SMAW)
- 2). OBG Field Splice 6W/7W weld ID: D1, Face A (FCAW-G)
- 3). OBG Field Splice 6W/7W weld ID: D1, Face A (FCAW-G)

- 1). OBG Field Splice 6E/7E weld ID: A1, Face A (R-1 UT Repairs SMAW)

The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing excavation by grinding of R-1 repair areas identified by QC. The QAI observed QC Inspectors Tom Pasqualone performing MT of the R-1 repair excavations prior to the commencement of welding. The QAI observed that the performance and evaluation of the MT appeared to comply with the MT procedure identified as SE-MT-CT-D1.5-101 Rev. 4. The QAI periodically observed AB/F approved welder Fred Kaddu (ID 2188) performing repair welding of the excavated areas per the Shielded Metal Arc Welding (SMAW) process. QC Inspector Tom Pasqualone was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-1000-Repair. The excavating and repair welding was in process and the work at this location appeared to be in general compliance with contract documents. See Summary of Conversations below.

- 2). OBG Field Splice 6W/7W weld ID: D1, Face A (FCAW-G)

The QAI periodically observed AB/F welder Xiao Jian Wan (ID 9677) performing welding per the Flux Cored Arc Welding (FCAW-G) process in the 1G (flat) to weld fill and cover passes. See photo below. Mr. Xiao Jian Wan

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

was welding the first 300mm of weld D1 adjacent to the counterweight side longitudinal diaphragm. QC Inspector Jesse Cayabyab was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-3040A-1.

Welding was completed at this location and work appeared to be in general compliance with contract documents.

3). OBG Field Splice 6W/7W weld ID: D1, Face A (FCAW-G)

The QAI periodically observed AB/F welder Hua Qiang Hwang (ID 2930) performing welding per the Flux Cored Arc Welding (FCAW-G) process in the 1G (flat) to weld fill and cover passes. Mr. Hua Qiang Hwang was welding the last 1200mm of weld D2 adjacent to the crossbeam side longitudinal diaphragm. QC Inspector Jesse Cayabyab was present to monitor the progress and verify that the welding parameters were within the limits established by the approved welding Procedure Specification (WPS) identified as ABF-WPS-D1.5-3040A-1.

Welding was completed at this location and work appeared to be in general compliance with contract documents.



Summary of Conversations:

From item 1).

The QAI while observing welder Fred Kaddu performing repair welding, inquired of the QC Inspector Mr. Tom Pasqualone if Mr. Kaddu was to proceed to repair a 670mm long indication at Y=1300mm –Y=1970mm that was adjacent to the repair he had just completed. Mr. Pasqualone stated that AB/F welding foreman Mr. Dan Ieraci had stated that this indication and another adjacent to it were not to be repaired because they were non relevant indications associated with a 1010mm long burn through that occurred during SAW.

Other conversations on this date with Quality Control Inspectors were general in nature and pertained to locations of welding and QC activities.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammed Fatemi (916) 813 3677, who represents the Office of Structural Materials for your project.

Inspected By: Madison,Bert

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer
